

Work Order ID 119286

May-15-14 10:17:21 AM

D 2734

B419286

\*119286\*

Page 1

Item ID: D2734

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Step End Plate

Stop

\*NS2\*

Start Date: 5/15/14

Start Qty: 100.00

\*100\*

Cust Item ID:

Required Date: 5/19/14

Req'd Qty: 100.00

\*100\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2734

Rev C

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D 2734

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

5052-063

150 0 Jm 14-05-16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

150 0 Jm 14-05-16

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

DAS

27

9-89

14/5/16

150 0 Jm 14-05-16

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**\*119286\***

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Item ID: D2734 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step End Plate  
 Start Date: 5/15/14 Start Qty: 100.00 **\*100\*** Cust Item ID:  
 Required Date: 5/19/14 Req'd Qty: 100.00 **\*100\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00		DAS					
<b>*130*</b>				30		150			
Small Fab	Memo	0.00		9-89					
Small Fab	Form as per drawing D2734								
140	QC5- Inspect part completeness to step on W/O	0.00							
<b>*140*</b>						150			
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: <u>WA1-003</u>	0.00							
<b>*150*</b>						150			
Packaging	Memo	0.00							
Packaging	*** STOCK IN STEP CELL***								

14/05/20

DAS  
27  
14/5/20

150  
can

14.05.22

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**Reference:**

Stop \*NR2\*

Accept Qty	Reject Qty	Reject Number	Insp. Stamp

0.00

## Memo

QC

## Quality Control

0.00

14/5/22

u14-0522

# Picklist Print

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Work Order ID: 119286

\*119286\*

Parent Item: D2734

\*D2734\*

Parent Item Name: Step End Plate

Start Date: 5/15/14

Required Date: 5/19/14

Start Qty: 100.00

Required Qty: 100.00

**Comments:**

IPP: D01.06.08Removed DeburEC

IPP Rev:E 07-12-18 RevC as per dwg ECN1048 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.063		Purchased	No			100	sf	234.1353	0.0625	7			

**\*M5052H32S 063\***

5052-H32 .063 Sheet

\*\*

Jm14-05-16

Location

Loc Qty

Loc Code

MAT022

234.1353

114322

25.7053

120603

17.69

121901

19.34

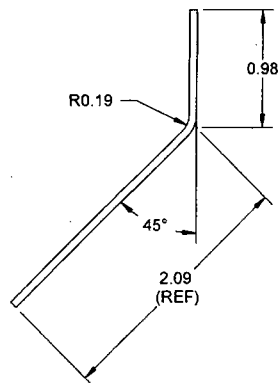
125272

63.4

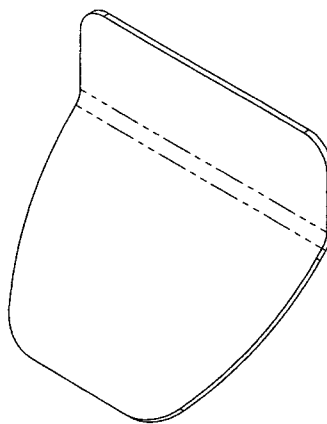
M128455

108

128455



**D2734 END PLATE**



**D2734 FLAT PATTERN**

**RELEASED**  
07.12.10

**NOTES:**

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET  
PER AMS-QQ-A-250/8 OR AMS 4016  
(REF. DART SPEC. M5052H32S.063) OR  
6061-T6 (OR 6061-T6) ALUMINUM SHEET  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs

C	ADD GRAIN DIRECTION NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.20
B	0.976 WAS 1.016, 2.097 WAS 2.137	KE	98.10.05
A	NEW ISSUE	KE	97.12.10
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	<b>D2734</b>	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	<b>END PLATE</b>	1:1
DATE	07.11.20	COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

